

Date: Thursday, 12/03/2009 10:34:47 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RIB ASSY (INBOARD)
Job Number	: 46476		
Estimate Number	: 13661		
P.O. Number	:	Part Number	: D3827041
This Issue	: 12/03/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3827 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 46090	Drawing Revision	: A
	Type	Material	:
	: LARGE FAB ASSY	Due Date	: 18/03/2009
Written By	:	Qty:	6 Um: Each
Checked & Approved By	: <u>JUD 09-03-12</u>		
Comment	: Est Rev:A 08-12-01 new issue DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D37591	Bushing
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Bushing

batch: B45794-314 B45890-314

PD 09-03-16

2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 8.4000 f(s)/Unit Total : 50.4000 f(s)

304 SQ Tube .75x.75x.065W

batch: M110969

SAD 09-03-12

6

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

SAD 09-03-12 (6)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

09-03-13 (6)

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- weld bushing in rib as per dwg D3827

A/R ER316 S.S. Rod Batch: M107051

PD 09-03-16 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/03/2009 10:34:47 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (INBOARD)

Job Number: 46476

Part Number: D3827041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- grind weld flush

3- deburr if necessary

PD 09.03.16 (6)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.03.16

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/16 (6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket

PD 09.03.16 (6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PD 09/03/16

Job Completion



U 09.03.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB

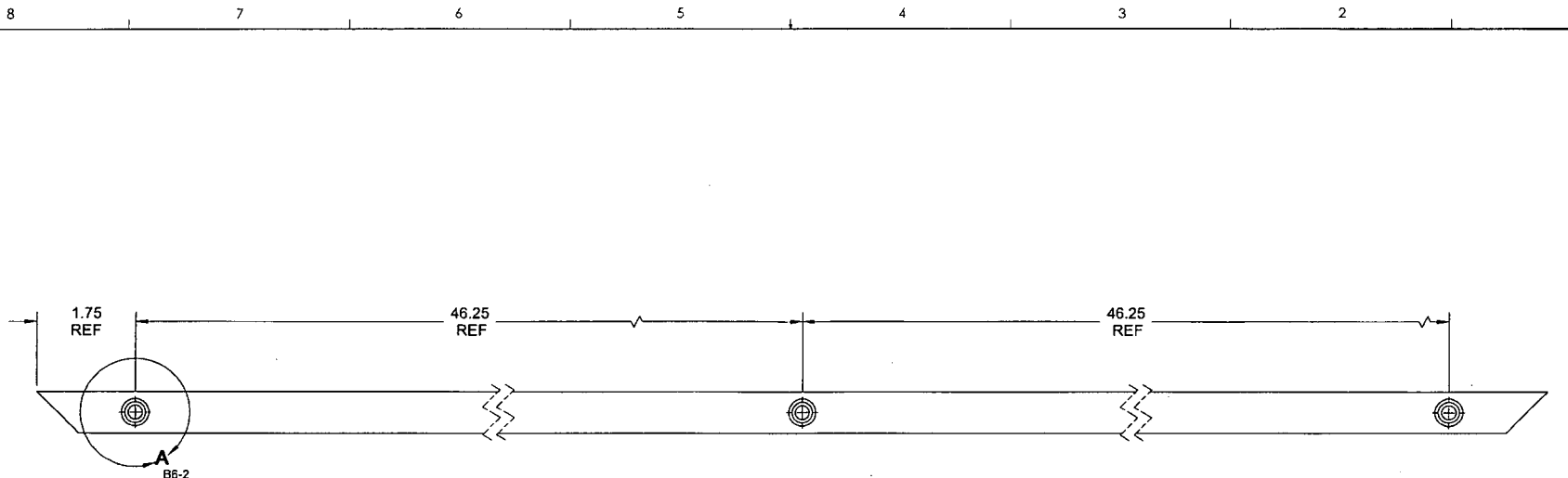
D3827-041 RIB ASSY (INBOARD)

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08/11/18

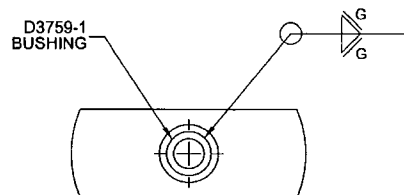
A		NEW ISSUE		MB		08.09.23	
REV.		DESCRIPTION		BY		DATE	
DESIGN				DART AEROSPACE LTD			
DRAWN				HAWKESBURY, ONTARIO, CANADA			
CHECKED		ASS		DRAWING NO.		REV. A	
MFG. APPR.		M		D3827		SHEET 1 OF 3	
APPROVED		M		TITLE		SCALE	
DE APPR.		M		RIB ASSY (INBOARD)		NTS	
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NO. 4102760
WORK ORDER
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- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.59 lbs



D3827-041 RIB ASSY (INBOARD)

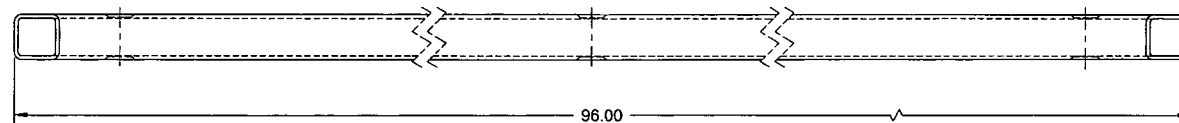
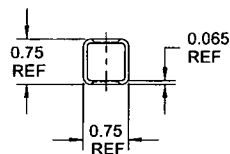
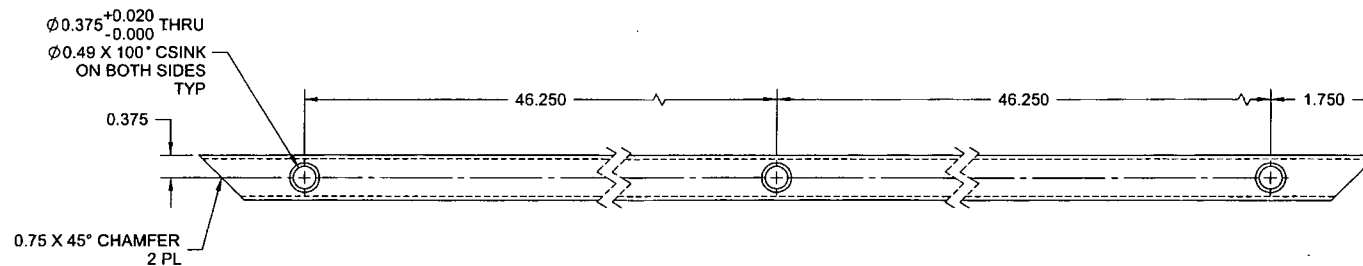


DETAIL A
SCALE 2X
3 PL

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CHECKED	ASS	DRAWING NO. D3827	REV. A
MFG. APPR.	MAO	SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.	#	RIB ASSY (INBOARD)	NTS
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D3827-1 RIB

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WORK ORDER
NO. 416412

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.55 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3827	REV. A
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (INBOARD)	NTS
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